



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-141
Job Sheet 167074-C



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-13 JSC
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	17/12/14 JSC
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	17/12/14 JSC
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	DEC 21 2017
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	17-12-27 D.M.L.
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/27 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-1 <u>5021492</u>	1	3	0	0
	D4636-5 <u>5021491</u>	1	43	0	0
	D4647-5 <u>5021490</u>	1	2	0	0
	D4664-5 <u>5021489</u>	6	39	0	0
	D4712-1 <u>5021484</u>	1	4	0	0
	D4732-15 <u>5021483</u>	1	2	0	0
	D4732-19 <u>5021482</u>	1	1	0	0
	D5021-1 <u>5021481</u>	1	2	0	0
	MPNY-750S-9-C <u>5021480</u>	7	570	0	0
	MS20426AD3-4 <u>5021479</u>	4	5,055	0	0
	MS20426AD4-6 <u>5021476</u>	2	2,797	0	0
	MS21059L08 <u>5021475</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		AGAINST DEPARTMENT/PROCESS									
Part No. _____				Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐			
NCR No. _____				Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐			
Date: _____				Forming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐			
				Large Fab ☐		Composite ☐		Supplier ☐					
		QTY Effective: _____								MRB (QSI042) Approval			
		Disposition											
												Completed By	
												Lead hand / Supervisor Approval Verification	
		QC / QA Coordinator Approval											

Root		DART AEROSPACE S021536		FAULT CATEGORY									
Environment ☐				ature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐					
Design ☐				oute ☐		Folio/Program ☐		Outside Dimensions ☐					
Doc/Data ☐		/Damage/Defect ☐		Grain ☐		Over/Under tolerance ☐							
Equip/Tooling ☐		ion Incomplete/Unqualified ☐		Weld ☐		Part Incorrect ☐							
Handling/Pre ☐		ination ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐							
Material ☐		rsink ☐		Out of Sequence ☐		Part Moved ☐							
Internal Transport ☐				Off-set ☐		Drawing ☐							
Tribal Knowledge ☐				Mislabeled ☐		Finish ☐							
LOA ☐				Fit/Function ☐		Misread ☐							
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